

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BEARPAW KIT (19"x16")
Job Number	: 30336		
Estimate Number	: 12616		
P.O. Number	: N/A	Part Number	: D058678011
This Issue	: 1/22/2007 S.O. No. : N/A	Drawing Number	: D2435 REV E1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: E1
Previous Run	: N/A	Material	: N/A
Written By	: _____	Due Date	: 2/12/2007
Checked & Approved By	: _____	Qty:	4
Comment	: Est Rev:A New Issue 07-01-03 JLM	Um:	Each

Figure 1. Schematic representation of the experimental design. The subjects were divided into two groups: the control group (C) and the experimental group (E). The control group (C) was divided into two subgroups: the control group (C) and the control group (C). The experimental group (E) was divided into two subgroups: the experimental group (E) and the experimental group (E). The control group (C) was divided into two subgroups: the control group (C) and the control group (C). The experimental group (E) was divided into two subgroups: the experimental group (E) and the experimental group (E).

1.0 DC DOCUMENT CONTROL



Photocopy bluefile:
and create labels per PPPD058-678-011 CHG 001
(Bag Bluefiles separately)

KS 07.01.25.

2.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 4.5491 sf(s)/Unit Total : 18.1965 sf(s)
blank: 19.500" x 16.00" x 1.00" thick (+0.030/-0.000) per DSK086-3
Material: Black UHMW 1"
(MUHMWB10)
Batch: M103428

JL 07/02/08

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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3-Deburr

J.L 07/02/09

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 07/02/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/22/2007 7:43:17 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X16")

Job Number: 30336

Part Number: D058678011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

MS 07/02/09 8

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

7.0

D2182B

Neoprene Cushion-.750 bl



Comment: Qty.: 1.6660 f(s)/Unit Total : 6.6640 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2182B050 Rubber Cushion B28042

8.0

D2274

Radius Block



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2274 Radius Block B28713 ✓

2 D2435(ref only) Bearpaw 30336

9.0

D2438

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2438 Clamp B28732 ✓

10.0

D2529

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2529 Washer M28733 ✓

CP 07/02/12 (9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/22/2007 7:43:17 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X16")

Job Number: 30336

Part Number: D058678011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

AN415A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN4-15A

Bolt

M102039 5x M103444 27x

12.0

AN417A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Bolt

Batch: *M101124*

13.0

AN960JD416

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN960JD416

Washer

M101938

14.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4

Nut (or -4)

M19185

15.0

QS200M44S

Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 QS200M44S

Clamp

M10338

1 Paperwork package

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: DP Date: 07/02/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/22/2007 7:43:18 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X16")

Job Number: 30336

Part Number: D058678011

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPD058-678-011

Location:

DART

2/24/02/13

2/16/13

(4)

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2/27/02/13

(4)

Job Completion



U 57-02.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	30336
Description: Bearpaw		Part Number:	D2435
Inspection Dwg: D2435 Rev: E1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.070x45°	✓			
B	5.500	+/-0.030	5.500	✓			
C	0.200	+/-0.030	.198	✓			
D	R0.250	+/-0.030	1.250	✓			
E	0.250	+/-0.010	.255	✓			
F	0.625	+/-0.030	.632	✓			
G	0.25 x 45°	+/-0.030	.245x45°	✓			
H	0.375	+/-0.010	.377	✓			
I	19.000	+/-0.030	19.00	✓			
J	0.950	+0.030/-0.010	.955	✓			
K	Ø0.260	+0.005/-0.000	.261	✓			
L	Ø0.930	+/-0.030	.932	✓			
M	0.30	+0.030/-0.000	.310	✓			
N	0.375	+/-0.030	.377	✓			
O	7.375	+/-0.030	7.376	✓			
P	4.250	+/-0.010	4.250	✓			
Q	2.000	+/-0.030	2.008	✓			
R	9.000	+/-0.010	9.001	✓			
S	15.750	+/-0.030	15.750	✓			

Measured by:	JL	Audited by:	MS	Prototype Approval:	N/A
Date:	07/02/08	Date:	07/02/08	Date:	

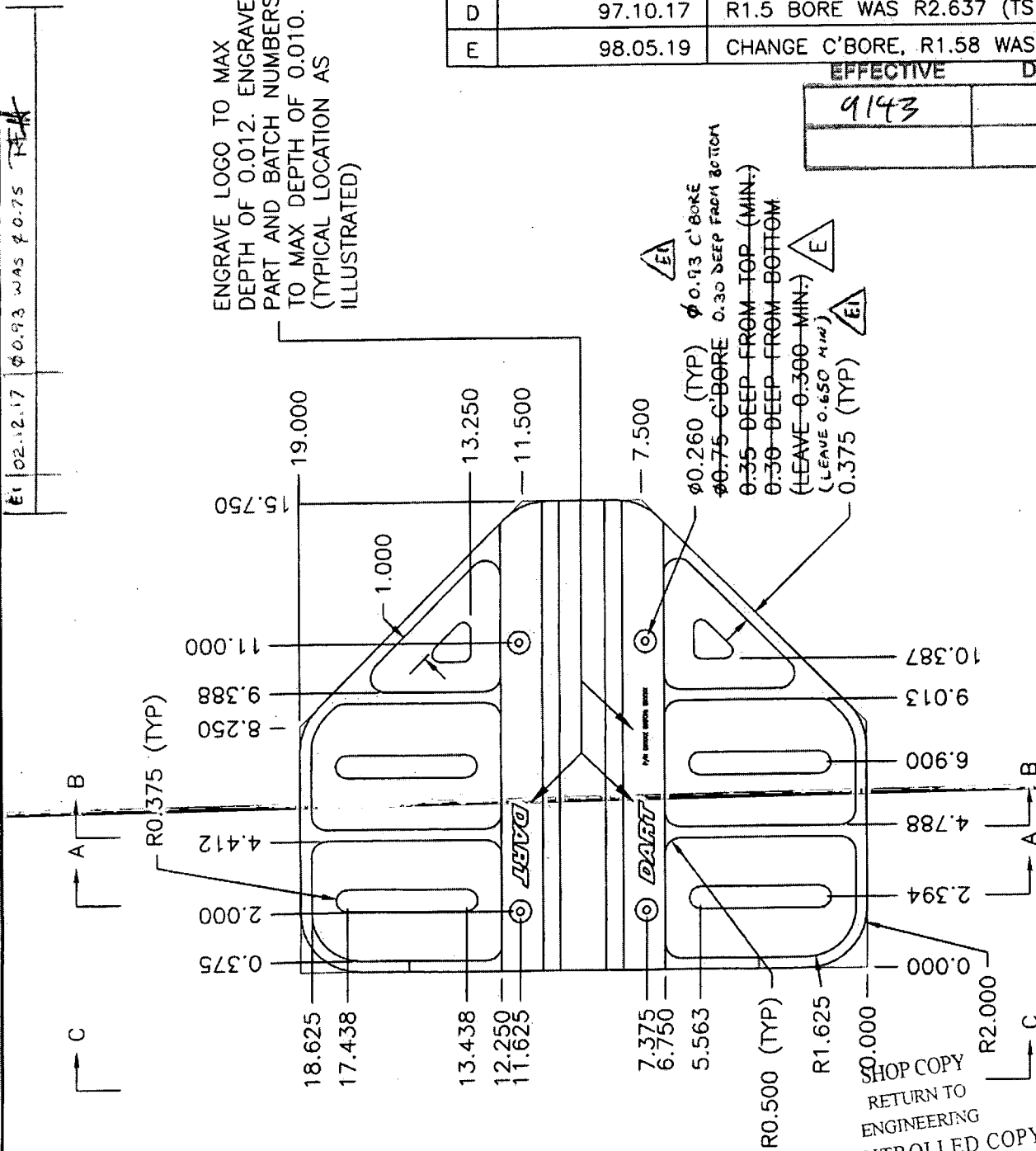
Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10007	KJ/RF TF	TF



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2435	REV. E SHEET 1 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:5
A	96.01.24	NEW ISSUE	
B	96.03.26	CHANGE BORE AND C'BORE DEPTH	
C	97.05.07	CHANNEL & C'BORE DEPTH CHANGED	
D	97.10.17	R1.5 BORE WAS R2.637 (TSR A469)	
E	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50	

EFFECTIVE DEOS

9143	

RELEASED
98.06.17 KEENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

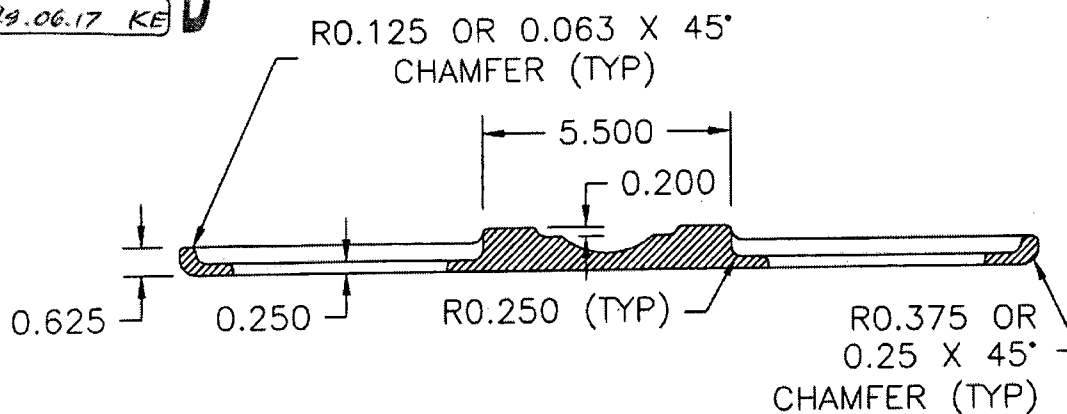
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30336

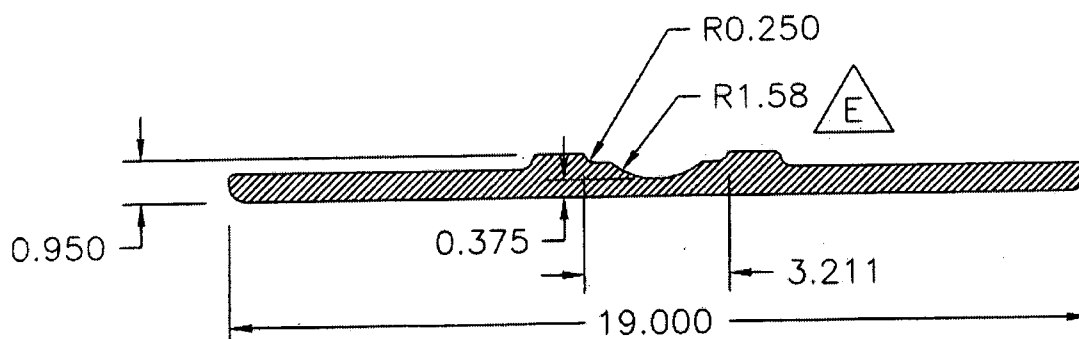


DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>DME</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19	TITLE BEARPAW		SCALE 1:4

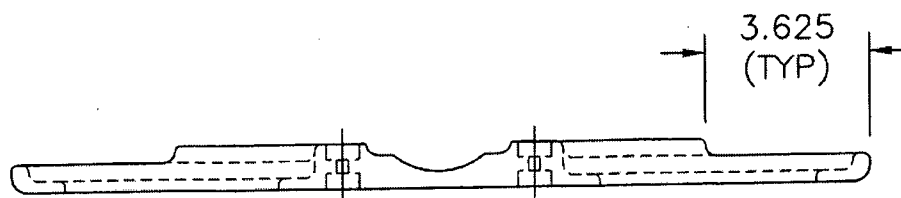
RELEASED
99.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C